



# DuPont OEM/Fleet Finishes

## TECHNICAL MANUAL

### TYPE

A high performance, low VOC (<3.5 lbs/gal RTS), epoxy polyamide primer. 934S is a two-component, light gray primer that is lead and chromate free.

### DESCRIPTION

CORLAR® 934S provides excellent durability and corrosion resistance, especially when topcoated with IMRON® 5000 or IMRON® 6000. It has very good viscosity/sag balance; it resists sagging even at higher film builds. And 934S has very good overspray melt-in, resulting in superior appearance. It provides excellent adhesion to a variety of substrates, especially aluminum. 934S has no induction period and offers fast dry times. Air dry, force dry or bake 934S. It is lead and chromate free and has <3.5 lbs/gal VOC.

### SUGGESTED USES

For use over properly treated substrates. Wash surface with a mild detergent. Clean and degrease with PREP-SOL® 3919S or DuPont reducer 3812S. Treat bare substrate as follows:

	CONDITIONER	CONVERSION
■ Steel	5717S	5718S
■ Aluminum	225S	226S

### NOT RECOMMENDED FOR

- Immersion service.
- Stainless steel

### COMPATIBILITY WITH OTHER COATINGS

Compatible with most topcoats. Highly recommended for use under Centari®, ChromaOne®, Imron®, Centari® 5000, Imron® 5000 or Imron® 6000 topcoats.

### DRY FILM CHARACTERISTICS\*

- Chemical Resistance -- VERY GOOD
- Humidity Resistance -- EXCELLENT (over treated substrate)
- Weatherability -- EXCELLENT, with appropriate top-coat
- Adhesion -- EXCELLENT
- Holdout -- GOOD to VERY GOOD
- Solvent Resistance -- EXCELLENT

### MAXIMUM SERVICE TEMPERATURE

- 200°F (92°C) in continuous service.
- 300°F (148°) in intermittent heat.

### VOLUME SOLIDS

- 52.5% as packaged
- 49.2% mixed 5:1 with 936S

### WEIGHT SOLIDS

- 74.4% as packaged
- 70.7% mixed 5:1 with 936S

### WEIGHT PER GALLON

- 13.2 lbs/gal as packaged
- 12.2 lbs/gal mixed 5:1 with 936S

### VOC CONTENT

- 934S: 3.4 lbs/gal as packaged; 3.4 lbs/gal ready-to-spray.
- 936S: 3.5 lbs/gal.

### SUGGESTED DRY FILM THICKNESS

- 0.8 - 1.8 mil

### THEORETICAL COVERAGE PER GALLON

- 790 sq. ft./gal @1 mil, mixed 5:1 with 936S.

### GLOSS

- Satin Sheen

### COLOR

- Gray

### FLASH POINT (CLOSED CUP)

- Between 20 - 73°F (-7 to -23°C)

### SHELF LIFE

- 12 months minimum.

### APPLICATION SOLVENTS

- Ready-to-spray below 3.5 lbs/gal VOC upon activation. Further reduction may result in greater than 3.5 lbs/gal VOC.

**CLEANUP THINNERS**

- DuPont Thinner 3602S
- Reducer 8685S

**ACTIVATION**

Mix five (5) parts 934S Primer with one (1) part 936S Activator. Shake primer prior to mixing.

**INDUCTION TIME**

- No induction time is required.

**POT LIFE (TIME/VISCOSITY)**

- Initial: 13 seconds
- After 30 minutes: 14 seconds
- After 1-2 hours: 15 seconds
- Maximum: 4-6 hours at 70°F

**ADDITIONAL COMMENTS**

- 934S is more of a sealer than a surfacer or filler. It is not designed for extensive sanding, especially after drying to a hard cure. Light overall or nib sanding can be done after air drying for 4-6 hours or force drying at 30 minutes at 180°F.

**APPLICATION CONDITIONS**

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 100°F (43°C). The substrate must be at least 5°F above the dew point. Relative humidity should be below 90%.

**APPLICATION**

- Thoroughly mix five parts 934S Primer with one part 936S Activator. Shake primer prior to mixing.
- No induction time is required.
- 934S builds at approximately 0.8 - 1.0 mils (wet) per pass with recommended gun setup.
- Apply using a cross-coat technique, top-to-bottom, then side-to-side. Each coat should be medium-wet with no flash between coats.
- Pressure pot or siphon application is recommended to provide the best atomization and delivery.
- Paint heaters can help provide a smoother appearance by controlling the temperature and viscosity of the product, especially under adverse or changing conditions.

**CURE TIME AT RECOMMENDED THICKNESS  
(AT 77°F & 50% RH)**

- Dry to Touch 30 min
- Tack Free 30 min
- Print Free 1 hr

Product must be sanded if allowed to dry for more than 72 hours. Products may be force dried 30 min at 140-180°F.

**APPLICATION EQUIPMENT**

- Pressure Pot (recommended)
- Siphon Gun
- Airless Spray
- Air Assisted Airless
- Gravity Feed Gun
- Suction Spray
- HVLP

**FOR VOC REGULATED AREAS**

These directions refer to the use of products which may be restricted or require special mixing instructions in your area. Follow recommendations in the DuPont compliant Products Chart for your area.

**SAFETY AND HANDLING**

DuPont is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels of all DuPont products before handling or using. These products are for industrial use by trained professional painters only.